

Work Order ID 64698

Tuesday, December 14, 2010 1:10:42 PM

Page 1

Item ID: D205-633-011

Accept

Setup Start

Revisor ID:

Stop

Item Name: Heli-Access-Step

Start Date: 12/14/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/12/11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

Salalax

OK for BGR-11/01/06

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/11 SP (42)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Salalax

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64698

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Tuesday, December 14, 2010 1:10:42 PM

Item ID: D205-633-011

Accept



Setup Start



Revision IP:

Stop



Item Name: Heli-Access-Step

Start Date: 12/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>70</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Signature 11/01/07 (40)

Signature 11/01/07 MF 11-01-07

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 12/14/2020

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A  Bolt		Purchased	No			110	Each	15.0000	1	4			
				<u>Location</u>									
				ST357				1					
					114752			1					
				ST358				14					
					110372			2					
					113359			12					
AN4-5A  Bolt		Purchased	No			110	Each	243.0000	2	8			
				<u>Location</u>									
				ST356				243					
					115016			43					
					115936			100					
					116191			100					
AN4-6A  Bolt		Purchased	No			110	Each	1,632.000	2	8			
				<u>Location</u>									
				ST356				1632					
					112933			96					
					113149			17					
					115108			119					
					115457			500					
					115936			200					
					116191			300					
					116400			400					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 64698

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Ste

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

AN4-7A Purchased No 110 Each 134.0000



Bolt



2 8
11/1/7 SP

Location

Loc Qty

Loc Code

ST356

134

113226

84

115373

50

8

AN5-14A Purchased No 110 Each 127.0000



Bolt



1 4
11/1/7 SP

Location

Loc Qty

Loc Code

ST

101

115374

101

ST337

26

115429

26

7

AN5-6A Purchased No 110 Each 22.0000



Bolt



1 4
11/1/7 SP

Location

Loc Qty

Loc Code

ST337

22

112243

22

✓

AN960JD416 NAS1149D0463J Purchased No 110 Each 30.0000



Washer



15 60
11/16/289 11/1/7 SP (42)

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 64698

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD516 NAS1149D0563J Purchased No



Washer

110 Each 34.0000 4 16



11/14/12 11/17/12

Location

Loc Qty

Loc Code

ST 34
103694 18
107534 12
109287 4

D2021-101 Manufactured No



Eyebolt

110 Each 29.0000 1 4



11/17/12

Location

Loc Qty

Loc Code

ST004 20
62464 20
ST005 9
59808 9

D2022-101 Manufactured No



Spacer

110 Each 90.0000 2 8



11/17/12

Location

Loc Qty

Loc Code

ST504 90
50746 23
52325 10
63318 57

D2022-103 Manufactured No



Spacer

110 Each 70.0000 2 8



11/17/12

Location

Loc Qty

Loc Code

ST004 70
47964 70

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 64698

Parent Item: D205-633-011

Parent Item Name: Hel Access-Step

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

D2562-001

Manufactured No

110

Each

8.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST264

8

61626

8

D2563

Manufactured No

110

Each

0.0000

1

4



Step Weldment Assembly

D2565-101

Manufactured No

110

Each

13.0000

1



Strut

Location

Loc Qty

Loc Code

ST270

13

60090

3

60503

10

D2565-103

Manufactured No

110

Each

11.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

11

60091

1

60504

10

D2565-105

Manufactured No

110

Each

11.0000

1



Strut

Location

Loc Qty

Loc Code

ST270

11

60092

1

60505

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64698

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

D2565-107

Manufactured No

110 Each

13.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST220

3

60093

3

ST270

10

60506

10



11/1/10

D2565-109

Manufactured No

110 Each

13.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

13

60094

3

60507

10



11/1/10

D2565-111

Manufactured No

110 Each

10.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

10

60508

10



11/1/10

MS21042L4

Purchased No

110 Each

4,634.000

8

32



Nut

Location

Loc Qty

Loc Code

ST300

4634

1123143

2

115589

32

115621

1100

116188

3500



11/1/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 64698

Parent Item: D205-633-011

Parent Item Name: Entry-Access-Step



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

1,251.000

2

8



Nut



11/17/10 40

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1225

115156

25

115594

500

116104

200

116105

500

8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21